

Work Order ID 74487



Page 1

Monday, October 03, 2011 10:41:52 AM

Item ID:	D3065-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Leg Assembly Hi					
Start Date:	9/30/2011	Start Qty:	40.00		Cust Item ID:	
Required Date:	10/28/2011	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan: <u>MLJ</u>	Date: <u>11/10/03</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3065	Rev B								

100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3065 and Identify as D3065-041								

ES 11/11/01 (40)

110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

SB 11/11/01

(40)

120	Identify as per dwg & Stock Location: <u>UA</u>	0.00							
Packaging	Memo	0.00							
Packaging									

Ae 11-10-01

X (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____





NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries


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Page 2

Monday, October 03, 2011 10:41:52 AM

Item ID: D3065-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Step Leg Assembly Hi
Start Date: 9/30/2011 Start Qty: 40.00  Cust Item ID:
Required Date: 10/28/2011 Req'd Qty: 40.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/11/13 
JMF
11-11-04

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 10:41:57 AM

Page 1

Work Order ID: 74487

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 9/30/2011

Required Date: 10/28/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPP KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3065-1 Step Spacer		Manufactured	No			100	Each	33.0000	1	40			
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Location	Loc Qty	Loc Code
GA	33	
69826	7	
73288	26	

D3065-3 Step Spacer		Manufactured	No			100	Each	27.0000	1	40			
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Location	Loc Qty	Loc Code
GA	27	
69827	1	
73290	26	

D3065-5 Step Leg		Manufactured	No			100	Each	21.0000	2	80			
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Location	Loc Qty	Loc Code
GA	21	
67222	1	
73289	20	

D3065-7 Step Spacer		Manufactured	No			100	Each	24.0000	1	40			
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Location	Loc Qty	Loc Code
GA	24	
73291	24	

Handwritten notes and signatures:

- Signature: *[Signature]*
- Text: B 74497
- Text: 7x
- Text: 26
- Text: 40
- Text: B 74498
- Text: 18x
- Text: 22
- Text: 80
- Text: B 74490
- Text: 79x
- Text: 1
- Text: B 74499
- Text: 23x
- Text: 17
- Text: 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 10:41:57 AM

Work Order ID: 74487



Parent Item: D3065-041



Parent Item Name: Step Leg Assembly Hi

Start Date: 9/30/2011

Required Date: 10/28/2011

Start Qty: 40.00

Required Qty: 40.00

MS20470AD4-4

Purchased

No

100

Each

4,190.000

30

1200



Rivet, Universal Head



Handwritten signature
11/11/01

Location

Loc Qty

Loc Code

ST139

78

117423

78

ST319

4112

116188

136

116391

66

118614

1910

119109

2000

420

M119386

780x

W/O:		WORK ORDER CHANGES					
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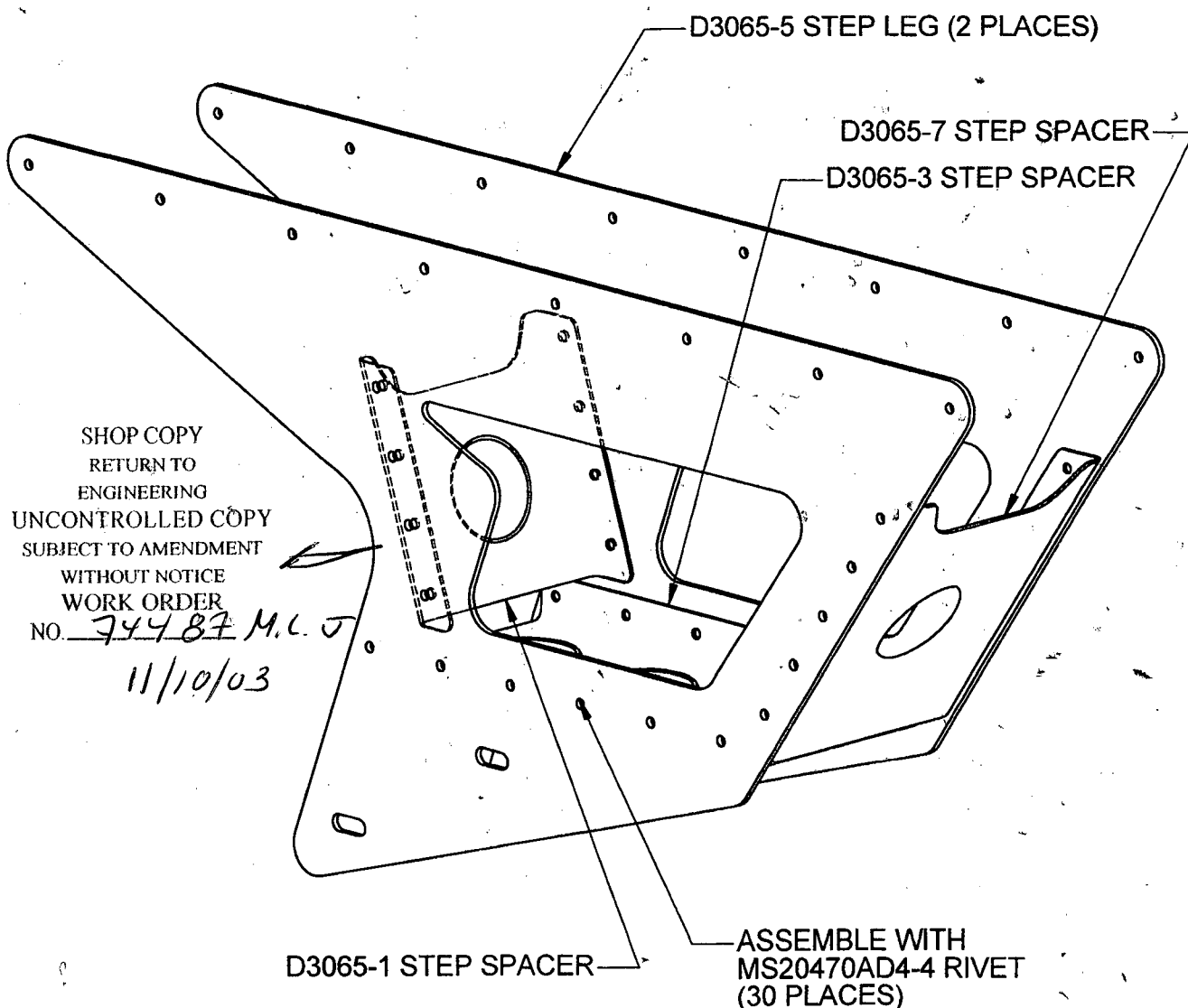
NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

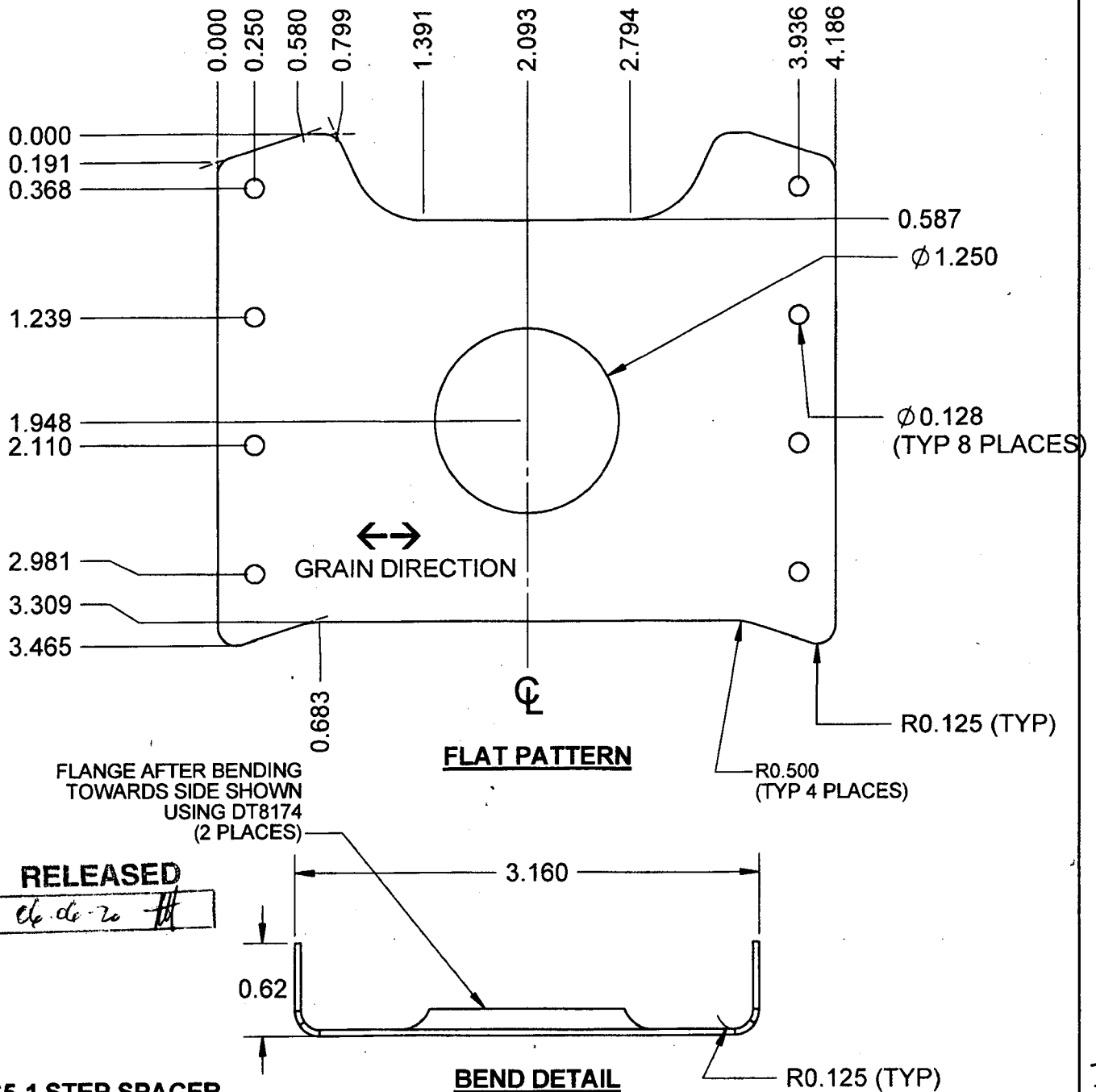
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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t8ht

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

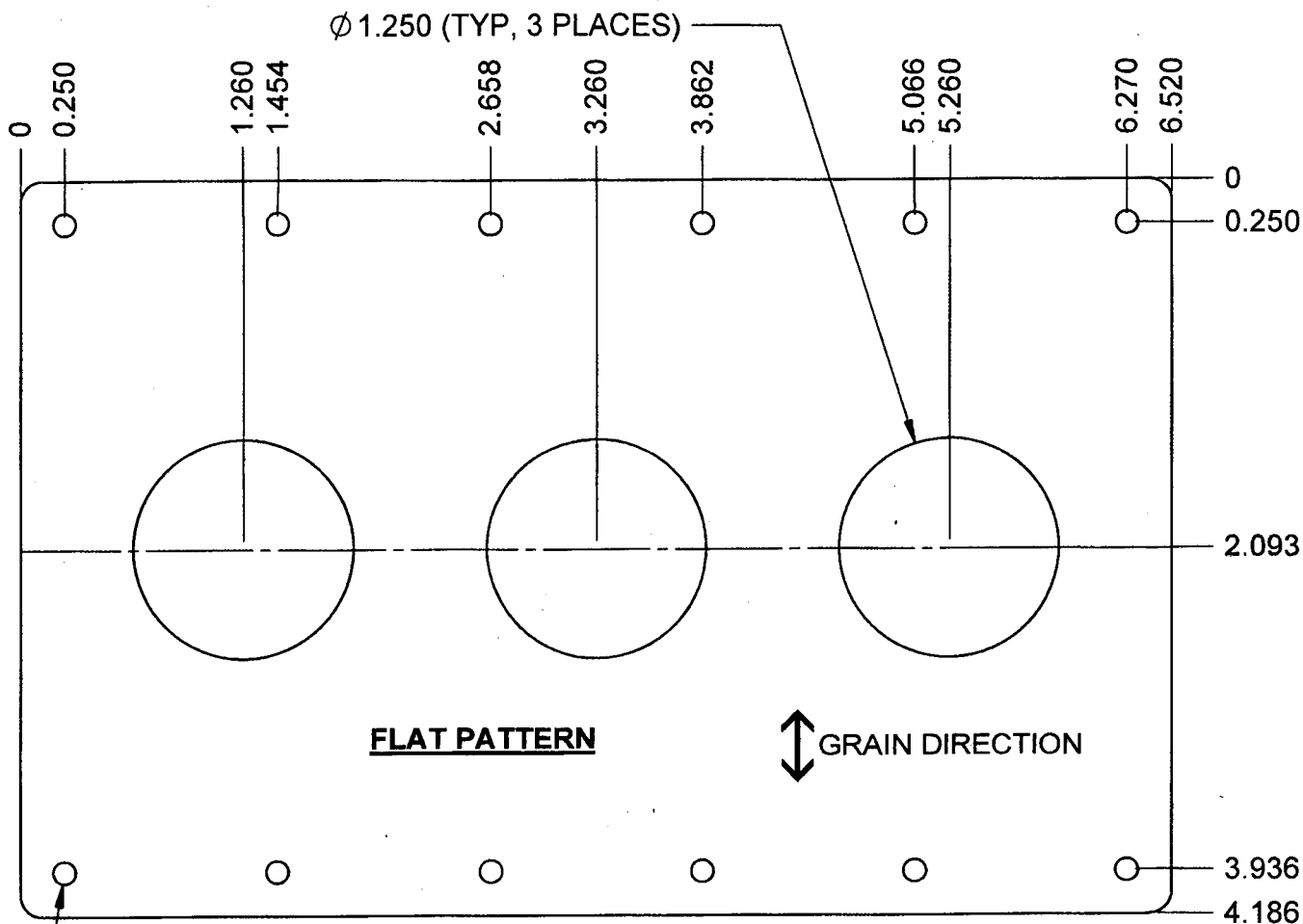
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

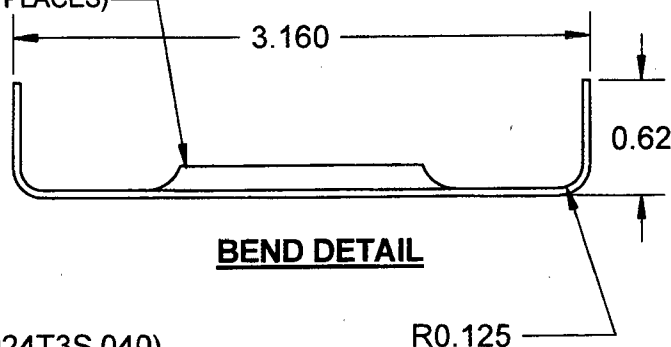


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.06.20 *[Signature]*



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

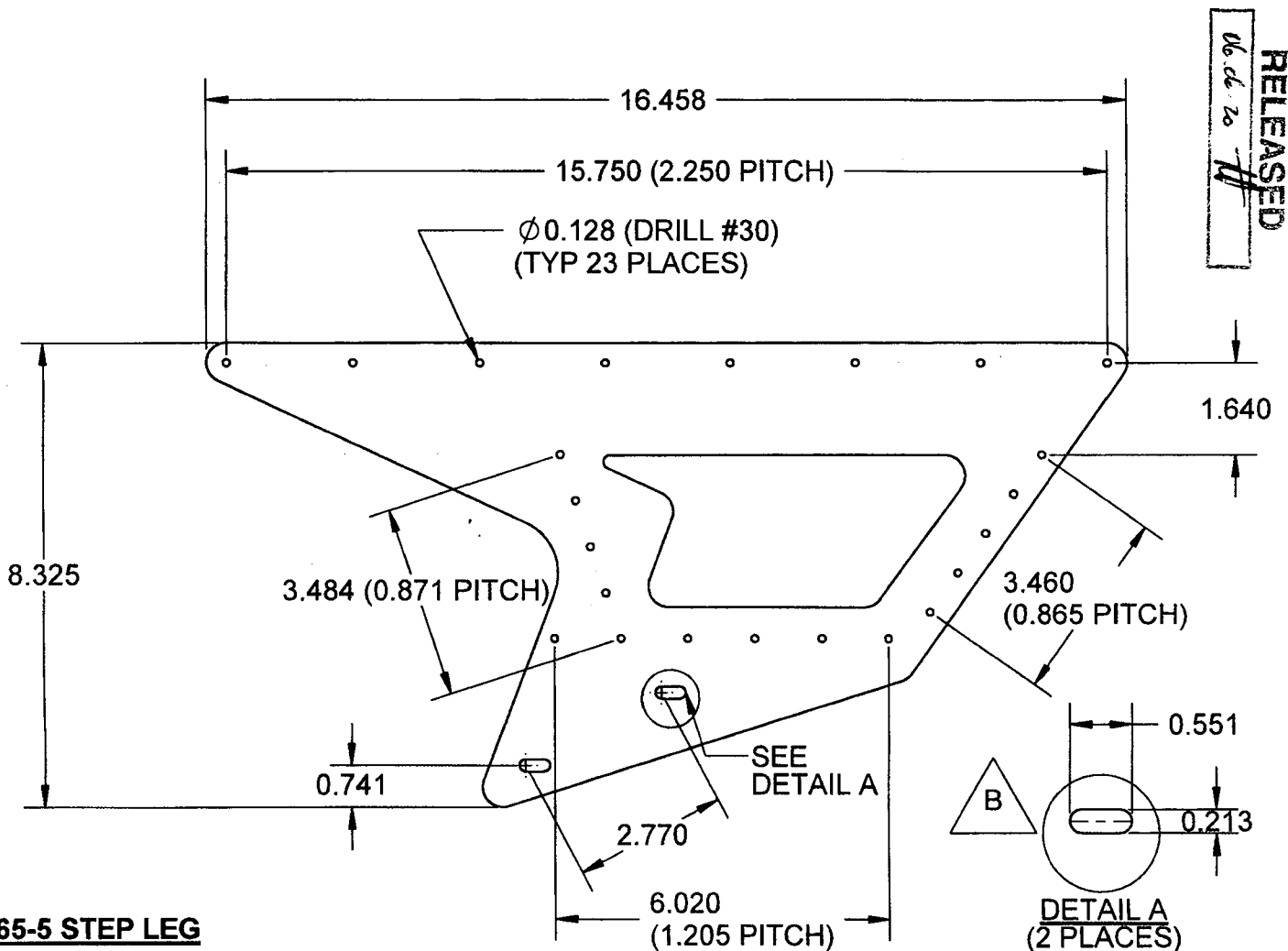
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
PH	[Signature]	D3065	SHEET 4 OF 5
DATE	06.05.23	TITLE	SCALE
		STEP LEG ASSEMBLY	1:3



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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tg hht

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

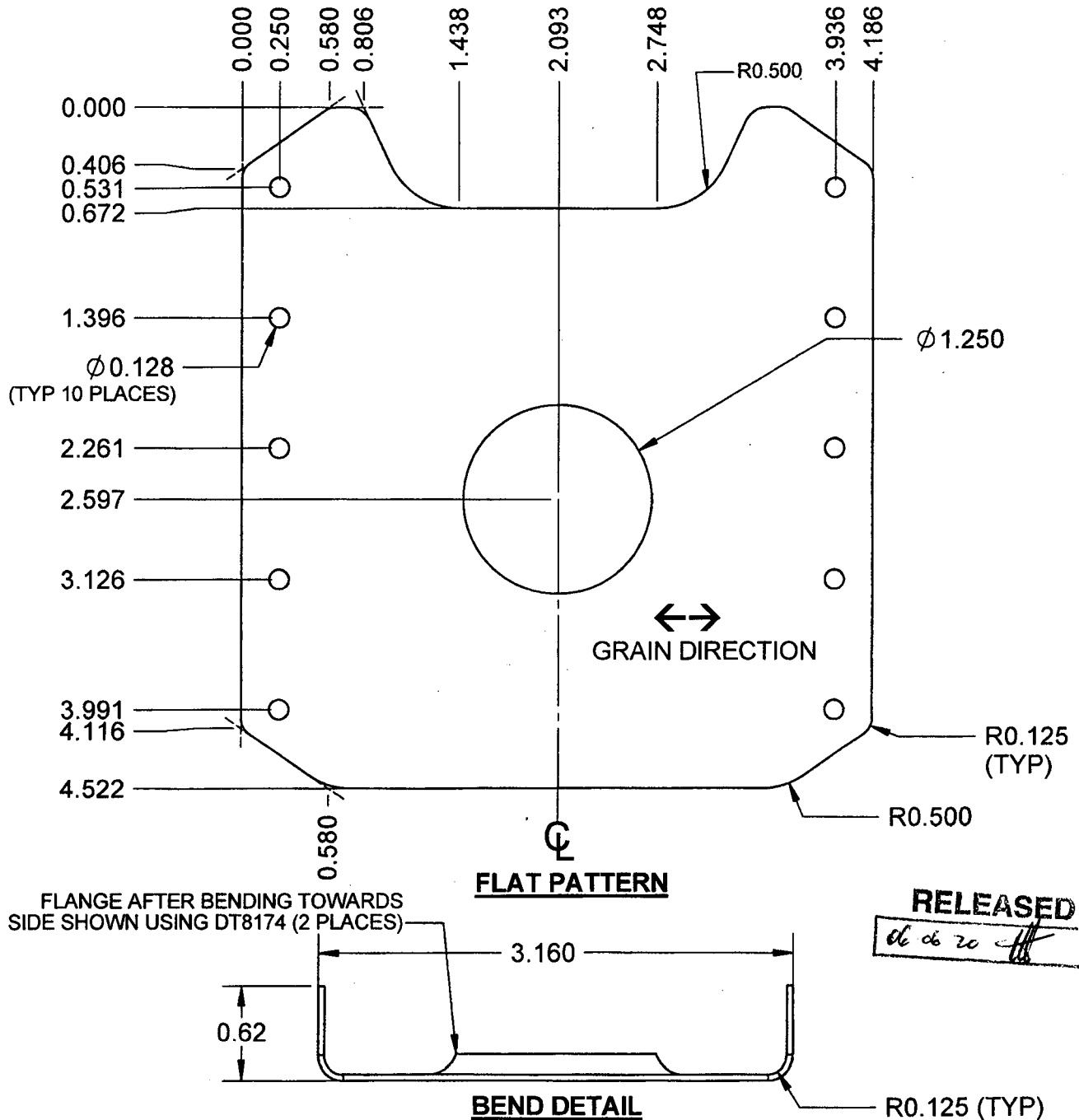
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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